

5/26

DART AEROSPACE LTD	Work Order:	23527
Description: Bracket	Part Number:	D3209-041
Dwg: D3209 Rev. A	Qty:	310

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	JF	05.06.08	10
2	MV	Cut blanks: 1.500" x 1.250" x 1.950" long Bar (+0.030/-0.000) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B1.500x01.250) Identify for D3209-1 Batch: M17037	JL	05/06/08	10
3	MV	Machine D3209-1 as per Folio FA345 and Dwg D3209 Identify as D3209-1	JL	05/06/08	10
4	QC2	Inspect parts as they come off the CNC machine	JL	05/06/08	10
5	MV	Deburr and Tumble	JL	05/06/08	10
6	QC8	Second check	JL	05.06.08	10
7	FP	Chemical conversion Coat as per QSI 005 4.1	MJ	05.06.08	10
8	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 Note: Cover the hole for D3209-1 before powder coat.	MJ	05.06.08	10
9	QC3	Inspect Powder Coat	JL	05.07.08	10
10	GA	Press fit bushing into the bracket as per Dwg D3209 Pick: Packing Kit Qty Part Number Description Batch 1 D3209-3 Bushing 9x B23204 Identify as D3209-041 1x B22081	JL	05.07.15	10
11	QC5	Inspect work to Step 10	JL	05.07.18	10
12	ST	Identify and Stock	JL	05.07.18	10
13	AC	Cost / part: 35.20	JL	05.07.21	10
14	DC	Close W/O 37.39 Inspect Level 21	JL ✓	05.07.23	10

Rev	Date	Change	Revised By	Approved
A	04.06.09	New issue	KJ/RF	HF

RELEASED

HF 04.06.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/06/20	3	<ul style="list-style-type: none"> Wrong part # engraved on 1 only 1 piece pushed down in vise piece is too thin 	J.L.	SCRAP: replace	2	2	BS/06/25	2 05-06-20

Part No: D3209-04

PAR #: _____

Fault Category: _____

NCR: Yes No DQA:

Date: 05/07/20

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

DART AEROSPACE LTD	Work Order:	23527
Description: Bracket	Part Number:	D3209-1
Inspection Dwg: D3209	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	J.L	Audited by:	<i>E</i>	Prototype Approval:	N/A
Date:	05/06/20	Date:	05.06.20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue (P/O D3209-041)	KJ/JLM	<i>[Signature]</i>

Job Costing Report

Dart Aerospace Ltd.
HawkesburyJun 07, 2005
11:54 am

Work Order No : 0023527
 Project Name : D3209-041
 Project For : WK526
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3209-041
 Description : Bracket
 Manufactured : Yes
 Amount Req'd : 3
 Amount Done : 0
 Start Date : 06-07-05
 Est Finish Date : 06-30-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

Est Mark Up : 0.000%
 Actual Mark Up : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden	0.00	0.00	0.00		
<hr/>					
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/ (Loss)	0.00	0.00

REFERENCE ONLY

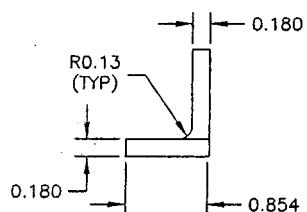
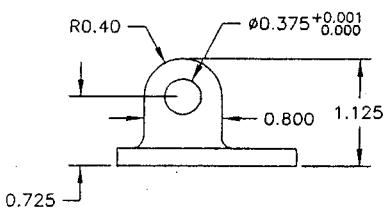
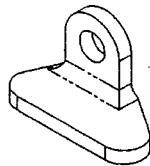
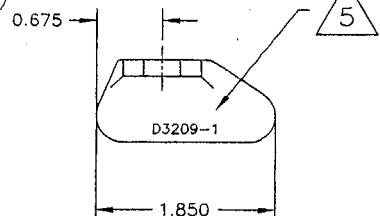
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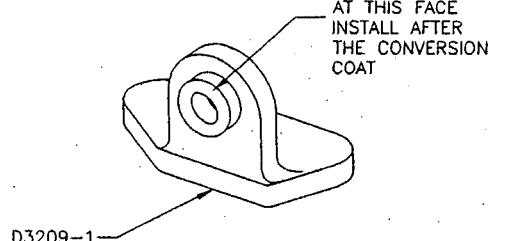
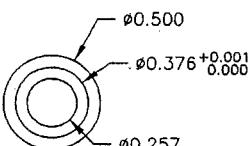
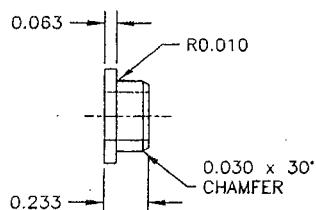
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3209	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.04.05 AF



2

D3209-1 BRACKET



3

D3209-3 BUSHING

SCALE 1:2

4

D3209-041 ASSEMBLY

D3209-1 BRACKET; D3209-3 BUSHING

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES

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